












Date: Monday, 07/04/2008 11:47:15 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 38431		
Estimate Number	: 12462		
P.O. Number	:	Part Number	: D35083
This Issue	: 07/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3508 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 33020	Drawing Revision	: C
Written By	:	Material	:
Checked & Approved By	: <u>JD 08.4.08</u>	Due Date	: 11/04/2008
Comment	: Est Rev:A New Issue 06-06-20 JLM Est Rev:B Now SS as per Rev B 06-12-15 JLM Est Rev:C Rev C dwg 07-12-06 DD	Qty:	6 Um: Each

Additional Product	

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		
Comment: Qty.: 0.7707 sf(s)/Unit Total : 4.6242 sf(s) 304 SS .038" THK (20GA) (M304S20GA) Batch: <u>106748</u> <u>HB 8-4-8</u>		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D3508 Dwg Rev: <u>C</u> <u>HB 8-4-8</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>HB 8-4-8</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-4-8</u>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <u>5 08/04/10</u> <u>89</u>		
5.0	BRAKE NC	NC BRAKE
		
Comment: NC BRAKE 1-Form on brake using DT8326 and DT8261 as per Dwg D3508 <u>83</u> <u>08/04/10</u> <u>8</u>		

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Drawing Name: WEARPLATE

Job Number: 38431

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Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Form joggle as per Dwg D3508 Using DT8158

SB 08/04/10

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/10 (18)

7.0

POWDER COATING

POWDER COATING



M 106442



(8X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/04/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/04/14 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FR-17

FD 08/04/14 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



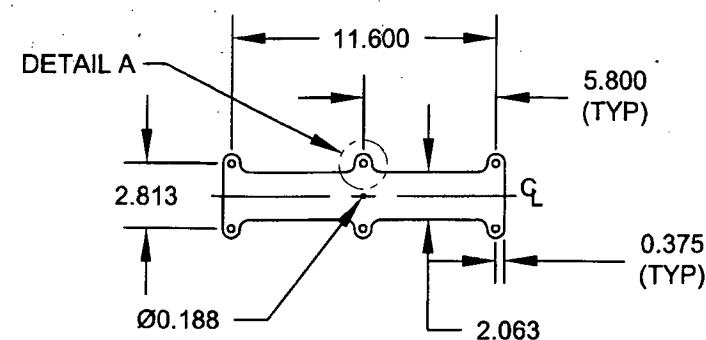
Comment: FINAL INSPECTION/W/O RELEASE

08/04/15

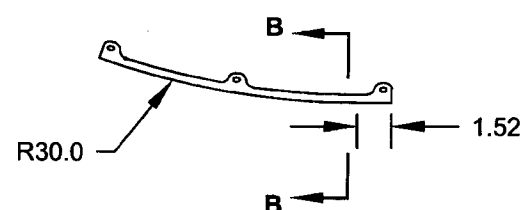
Job Completion



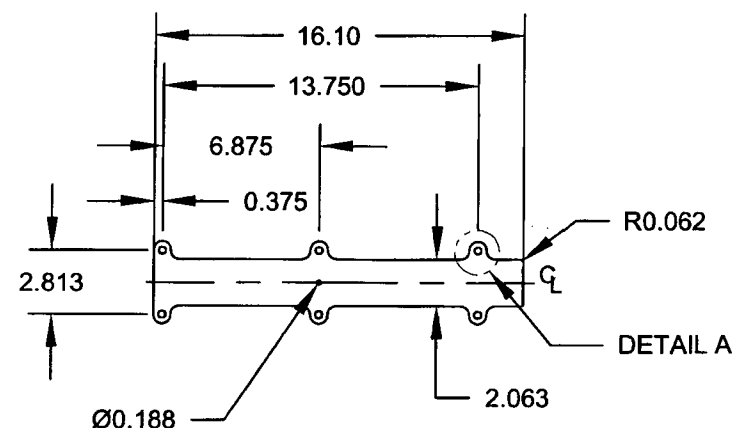
U 08-04-14



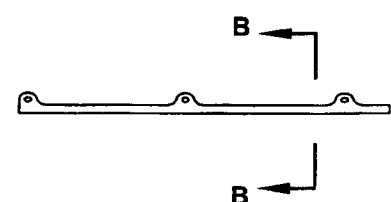
D3508-1 FLAT PATTERN



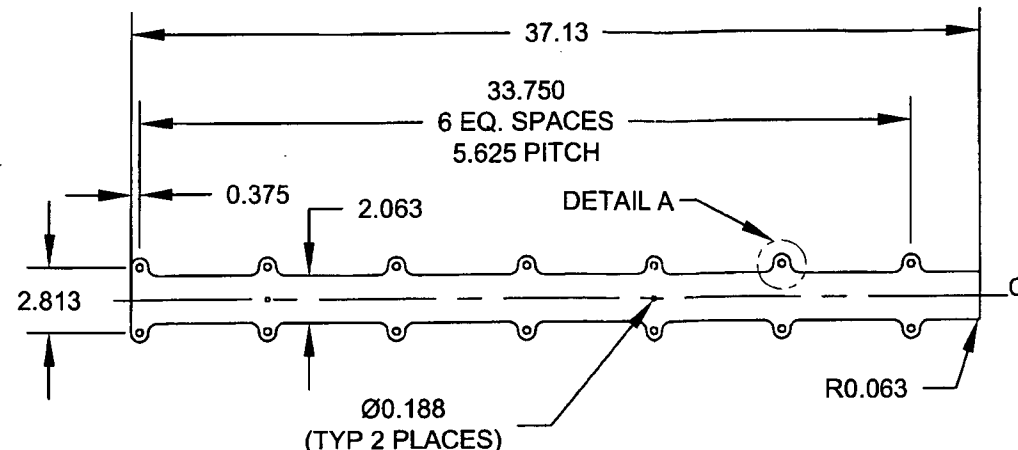
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



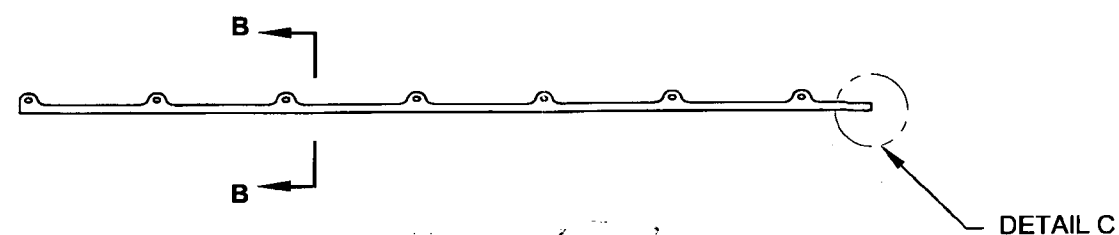
D3508-7F FLAT PATTERN



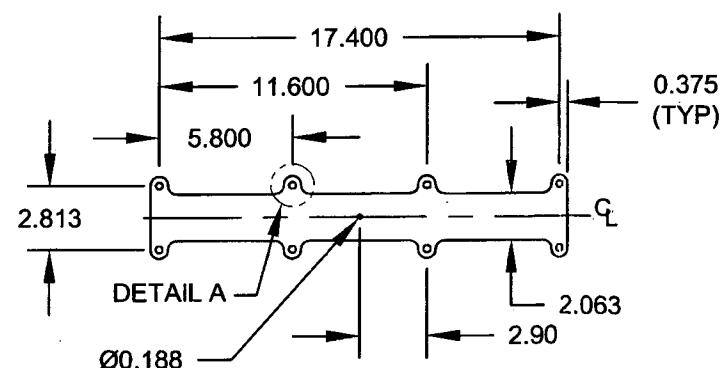
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



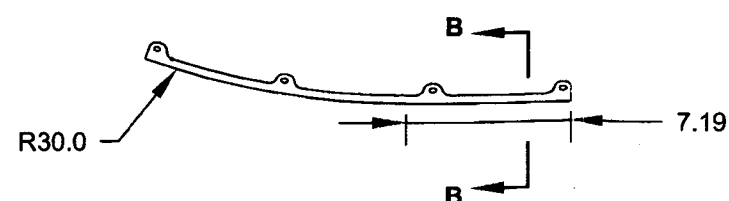
D3508-3 FLAT PATTERN



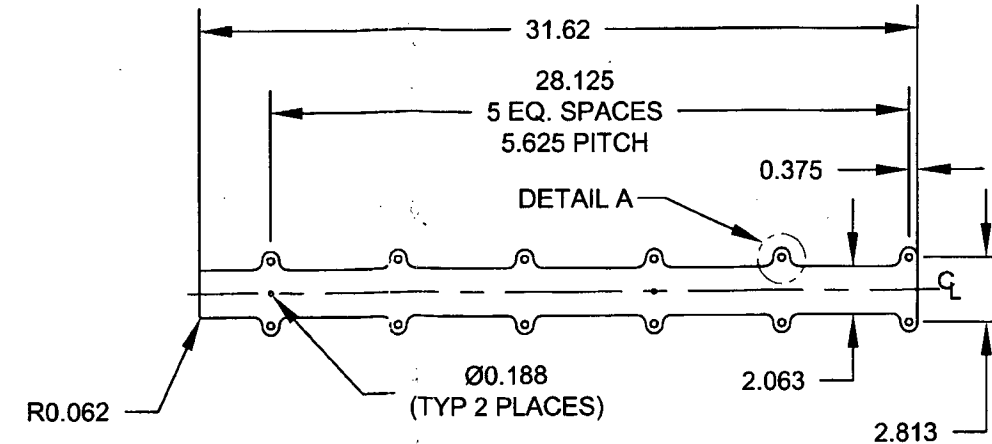
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



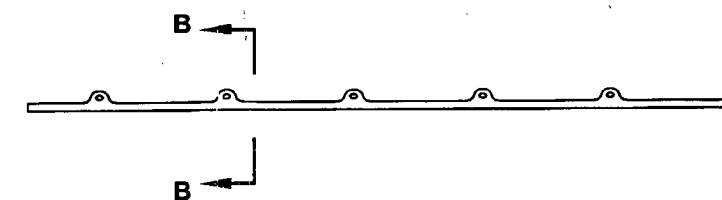
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

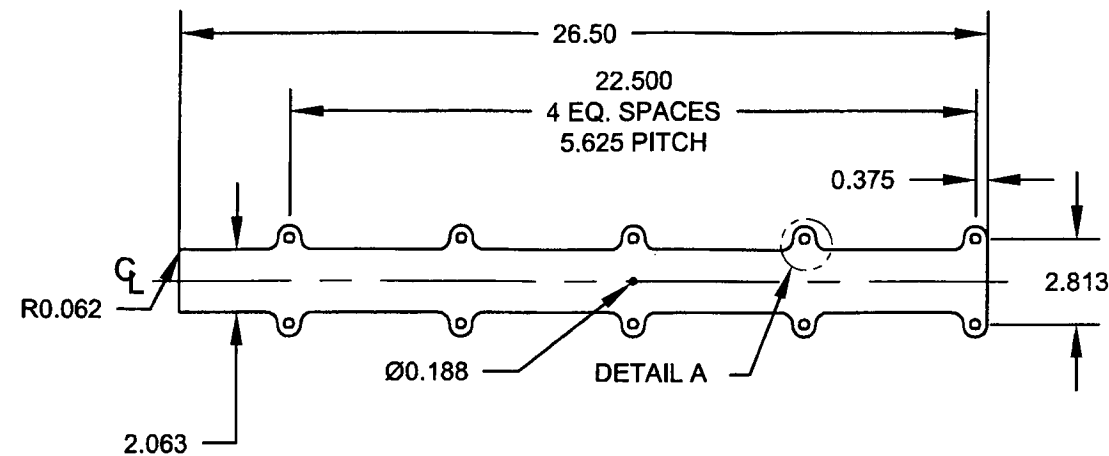
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

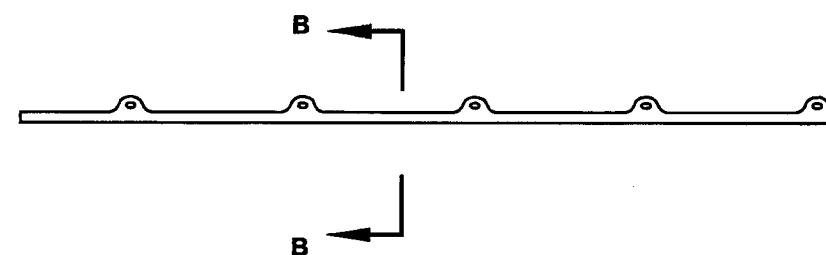
RELEASED
07.11.16

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	24	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	24		
CHECKED	14	DRAWING NO. REV. C	
MFG. APPR.	14	D3508 SHEET 1 OF 2	
APPROVED	14	TITLE SCALE	
DE APPR.	14	WEARPLATE 1:8	
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

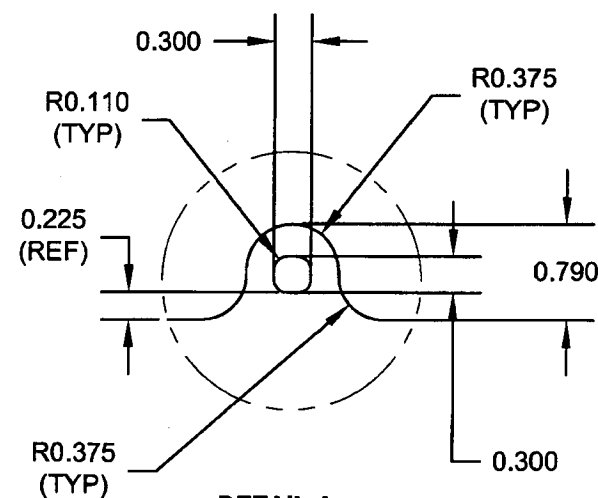
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WITHOUT NOTICE
WORK ORDER
NO. 3843



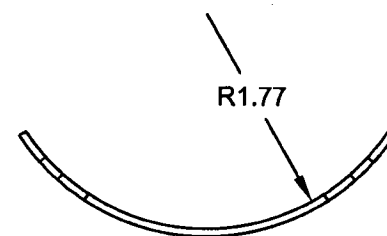
D3508-11F FLAT PATTERN



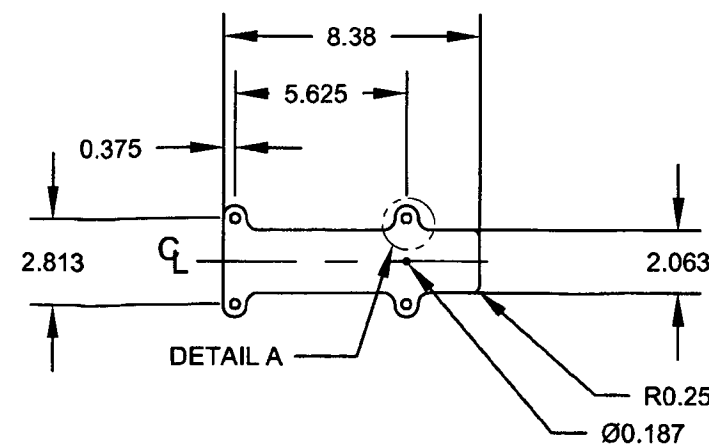
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



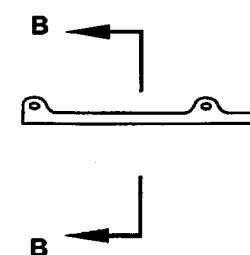
DETAIL A
(SCALE 2:3)



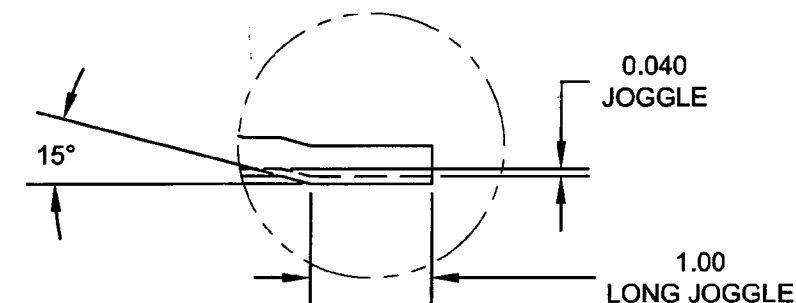
SECTION B-B
(SCALE 2:3)



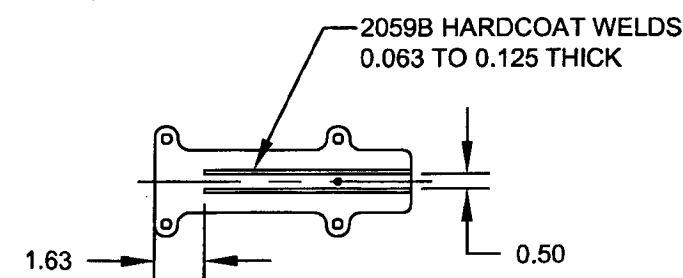
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

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NO. 38431

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO. D3508	REV. C
MFG. APPR.	E		SHEET 2 OF 2
APPROVED	PH	TITLE WEARPLATE	SCALE 1:6
DE APPR.	PH		
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